

Work Order ID 162541

162541

Page 1

Monday, June 05, 2017 9:30:29 AM

Item ID: D350-822-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: PA100 PUREair System for AS350/EC130 - Provisions
 Start Date: 6/1/2017 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 6/5/2017 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUN 07 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-822	6 17-7-11	DAS 6 9-89							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.04							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-822-013 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.04							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

JUL 06 2017

JUN 28 2017

JUL 06 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

Work Order ID 162541

Monday, June 05, 2017 9:30:29 AM

162541

Page 2

Item ID: D350-822-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/5/2017 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging					2		DAS 27 8-89	
Packaging	Memo	0.06							
Packaging	Identify and pack for shipping as per PPP D350-822-013 Location: <u>fs037</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

JUL 06 2017

AUG 25 2017

AUG 25 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
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OTHER : ☐																					

Picklist Print

Monday, June 05, 2017 9:30:27 AM

Page 1

Work Order ID: 162541

162541

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 16.09.01 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

23350CA050

Purchased

No

110

Each

77.0000

2

4

23350CA050

WASHER

**

DAS
6
9-89

DAS
28
9-89

JUN 28 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST579

77

m135603

77

650.0401

Manufactured

No

110

Each

11.0000

1

2

650 0401

PUREair Fairing Assembly

**

DAS
6
9-89

DAS
28
9-89

JUN 28 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

FG107

7

155153

1

155154

1

155155

1

155156

1

155157

1

155158

1

155159

1

FG108

2

155151

1

155152

1

FG109

2

155160

1

155161

1

8411999090

9752100180

Purchased

No

110

Each

0.0000

1

2

8411999090

Gasket - P/N 9752100180

**

DAS
6
9-89

DAS
28
9-89

JUN 28 2017

DAS
27
9-89

1 x M 137961

13552/K1

155160

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Page 2

Work Order ID: 162541

162541

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

9752018044

Purchased

No

110

Each

4.0000

1

2

9752018044

Gasket (for B3 models)

**

DAS
6
9-89

JUN 2 9 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST589

4

m136535

4

DAS
27
9-89

9945000120

Purchased

No

110

Each

15.0000

1

2

9945000120

Gasket (for B3e models)

**

DAS
6
9-89

JUN 2 9 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST589

15

m136629

15

AS
27
9-89

AN821-12I-89

Purchased

No

110

Each

9.0000

2

4

AN821-12.I

Elbow (or AN821-12K or 12S)

**

DAS
6
9-89

JUN 2 9 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

OVER007

6

M137587

6

ST324

3

M137047

3

DAS
27
9-89

AN929-12I

Purchased

No

110

Each

9.0000

1

2

AN929-12.I

Cap

**

DAS
6
9-89

JUN 2 8 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST322

9

m136648

1

m137333

4

m137587

4

DAS
27
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Page 3

Work Order ID: 162541

162541

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

D4925-041

Manufactured No

110 Each

5.0000

1 2

D4925-041

Mounting Plate Assembly

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST218

5

151082

1

159038

4

D4931-1

Manufactured No

110 Each

2.0000

1 2

D4931-1

Engine Fitting (for acft models B2 & previous)

**

DAS
27
9-89

Location

Loc Qty

Loc Code

st138

2

155900

2

D4931-3

Manufactured No

110 Each

8.0000

1 2

D4931-3

Engine Fitting (for B3 models)

**

DAS
27
9-89

Location

Loc Qty

Loc Code

st138

8

158799

8

D4931-5

Manufactured No

110 Each

3.0000

1 2

D4931-5

Engine Fitting (for B3e models)

**

DAS
27
9-89

Location

Loc Qty

Loc Code

st138

3

155870

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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162541

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

D4935-1 Manufactured No 110 Each 62.0000 6 12

D4935-1

Mounting Bracket

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

Location Loc Qty Loc Code

ST139 62

158010 12

159896 50

12

D4943-1 Manufactured No 110 Each 8.0000 1 2

D4943-1

Flex Hose

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

Location Loc Qty Loc Code

st220b 8

155430 8

2

D4961-041 Manufactured No 110 Each 4.0000 1 2

D4961-041

Tube Assembly

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

Location Loc Qty Loc Code

ST139 4

159053 2

159535 2

2

D4961-043 Manufactured No 110 Each 5.0000 1 2

D4961-043

Tube Assembly

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

Location Loc Qty Loc Code

ST140 5

156327 1

158818 4

1

DAS
27
9-89

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Shop Packet Print

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 5

Work Order ID: 162541

162541

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

D5079-1

Manufactured No

110 Each

10.0000

2 4

D5079-1

Placard, EAPS

**

JUN 28 2017

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST148

10

159498

6

3/18/2018

158099

4

3/21/2018

D5090-041

Manufactured No

110 Each

5.0000

1 2

D5090-041

Duct Assembly

**

JUN 28 2017

DAS
6
9-89

DAS
28
9-89

New rev. D

DAS
27
9-89

Location

Loc Qty

Loc Code

st222B

5

151509

1

159050

4

D5105-1

Manufactured No

110 Each

6.0000

2 4

D5105-1

Handle

**

JUN 28 2017

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

st151

6

157998

6

D5110-1

Manufactured No

110 Each

6.0000

1 2

D5110-1

Swivel Nut Fitting

**

JUN 28 2017

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST152

6

150856

6

Monday, June 05, 2017 9:30:28 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, June 05, 2017 9:30:28 AM

Work Order ID: 162541

162541

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

D5179-1
D5179-1

Doubler

Manufactured No

110 Each

25.0000

2 4

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST220

25

149870

1

158420

4

159962

20

D5179-3
D5179-3

Doubler

Manufactured No

110 Each

4.0000

2 4

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST220

4

155896

4

D5194-1
D5194-1

Doubler

Manufactured No

110 Each

6.0000

2 4

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST220

6

158435

6

D5208-041
D5208-041

Blanking Plate Assembly

Manufactured No

110 Each

11.0000

3 6

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST158

11

158361

11

162526

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																									

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Work Order ID: 162541

162541

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

EN3686-050016

Purchased

No

Each

33.0000

2

4

FN3686-050016

Screw

AS PER ECW 17-582
N/A Rev. 6
17-7-11

DAS
03
9-89

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST561

33

m135700

1

m137156

32

DAS
27
9-89

DAS
9-89

LN9038-05012

Purchased

No

110

Each

200.0000

I N9038-05012

Bolt

36 DAS 3
17-7-11 Rev. 6
03 9-89 72

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST564

200

m135704

20

m137112

130

m137621

50

DAS
27
9-89

DAS
27
9-89

LN9038-05040

Purchased

No

110

Each

56.0000

1

2

I N9038-05040

Bolt

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

st555

16

m135803

16

ST572a

20

m136260

20

st579A

20

m135703

20

DAS
27
9-89

LN9348-05

Purchased

No

110

Each

207.0000

26

52

I N9348-05

Nut

**

DAS
6
9-89

JUN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST564

207

m135704

207

DAS
27
9-89

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
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Work Order ID: 162541

162541

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

MS20470AD3-4

Purchased

No

110

Each

4,888.000

18

36

MS20470AD3-4

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

1031

m136851

1031

ST310

3857

m136665

3857

MS21919WCH12

Purchased

No

110

Each

23.0000

1

2

MS21919WCH12

Clamp

Location

Loc Qty

Loc Code

OVER007

20

m137371

20

ST291

3

m135600

3

MS9592-138

Purchased

No

110

Each

9.0000

1

2

MS9592-138

Bracket

Location

Loc Qty

Loc Code

ST267

9

m137075

9

DAS

03

9-89

DAS

27

9-89

DAS

27

9-89

DAS

03

9-89

DAS

27

9-89

AUG 17 2017

B

1641633X1

163408 X1

Shop Packet Print

Monday, June 05, 2017 9:30:28 AM

AUG 02 2017

Page 8-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Picklist Print

Monday, June 05, 2017 9:30:28 AM

Page 9

Work Order ID: 162541

162541

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

110

Each

791.0000

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

FP		225
m136015		8
m137075		217
GA		308
m136643		308
ST264		258
m136015		0
m137412		258

110

Each

8.0000

1

2

NAS43DD3-64

Purchased

No

NAS43DD3-64

Spacer

Location

Loc Qty

Loc Code

GA		5
m132461		5
ST550		3
m135603		3

DAS 03 8-89 12-7-11 Rev. 6

58 116 132 66

DAS 27 9-89

DAS 27 9-89

DAS 6 9-89

JUN 28 2017

DAS 28 9-89

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DAS 6 9-89

AUG 09 2017

1379631/0

DAS 28 9-89

JUN 28 2017

DAS 6 9-89

DAS 27 9-89

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		D350-822-011	PA100 PUREAIR SYSTEM
	X	D350-822-013	PA100 PUREAIR PROVISIONS
1		QB05008	PUREAIR SYSTEM
1**		QR10616	TUBE REPAIR KIT
1**		QB21304	PUREAIR PANEL ASSY
1**		QB21310	TRANSITION DUCT ASSY
1**		QB21308	FOD SCREEN ASSY
15**		LN29985-A05	ANCHOR NUT
56**		LN9038-05018	BOLT
56**		BS4320-A5	WASHER
40**		MS20426AD3-3	RIVET
1	1	650.0401	PUREAIR FAIRING ASSY
1	1	D4925-041	MOUNTING PLATE ASSY
1*	1*	D4931-1	ENGINE FITTING
1*	1*	D4931-3	ENGINE FITTING
1*	1*	D4931-5	ENGINE FITTING
6	6	D4935-1	MOUNTING BRACKET
1	1	D4943-1	FLEX HOSE
1	1	D4961-041	TUBE ASSEMBLY
1	1	D4961-043	TUBE ASSEMBLY
2	2	D5079-1	PLACARD
1	1	D5090-041	DUCT ASSEMBLY
2	2	D5105-1	HANDLE
1	1	D5110-1	SWIVEL NUT FITTING
2	2	D5179-1	DOUBLER
2	2	D5179-3	DOUBLER
2	2	D5194-1	DOUBLER
3	3	D5208-041	BLANKING PLATE ASSY
1*	1*	9752100180	GASKET
1*	1*	9945000120	GASKET
2	2	23350CA050	LOCKING TAB
2	2	AN821-12J	ELBOW (OR AN821-12K OR AN821-12S)
1	1	AN929-12J	CAP
58	58	BS4320-A5	WASHER (OR NAS1149D0332J)
2	2	EN3686-050016	SCREW
32	32	LN9038-05012	BOLT
1	1	LN9038-05040	BOLT
26	26	LN9348-05	NUT
18	18	MS20470AD3-4	RIVET
1	1	MS21919WHG12	CLAMP
1	1	MS9592-138	BRACKET
1	1	NAS43DD3-64	SPACER

* USE APPROPRIATE FITTING/GASKET BASED ON ENGINE INSTALLATION

** PART OF QB05008 ABOVE

Work Order ID 162541***162541***

Page 1

Monday, June 05, 2017 9:30:29 AM

Item ID: D350-822-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/5/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start ***NR1***Approvals: Process Plan: _____ Date: **JUN 07 2017** Tooling: _____ Date: _____Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-822	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.04							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-822-013 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.04							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

402 1 2 N00

DAS
5
9-89

JUN 22 2017



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH14-14

Issue No.: 2

Approval Date: June 12, 2014

Issue Date: July 23, 2015

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

Airbus Helicopters AS 350 B, AS 350 B1, AS 350 B2,
AS 350 B3, AS 350 BA, EC 130 B4, EC 130 T2.

Canadian Type Certificate or Equivalent:

H-83

Description of Type Design Change:

Installation of an Active Vortex Tube Inlet Filtration System
(PA100 PUREair System)

**Installation/Operating Data,
Required Equipment and Limitations:**

Installation of the PA100 PUREair System must be in accordance with Transport Canada Civil Aviation (TCCA) approved Dart Aerospace Ltd. Installation Instructions IIN-D350-822 Revision E, dated July 20, 2015 or later TCCA approved revision.

Operation with the PA100 PUREair System installed must be in accordance with TCCA approved Dart Aerospace Ltd Flight Manual Supplement FMS-D350-822 Revision B, dated July 21, 2015, or later TCCA approved revision.

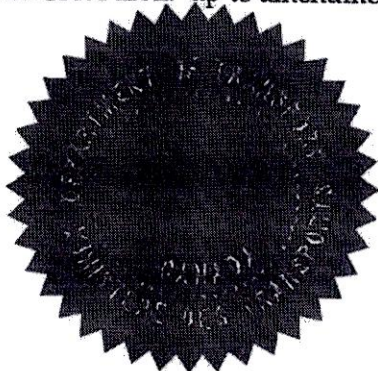
Maintenance of the PA100 PUREair System must be in accordance with TCCA accepted Dart Aerospace Ltd. Instructions for Continued Airworthiness ICA-D350-822 Revision 2, dated July 21, 2015, or later TCCA accepted revision.

Definition of the Type Design Change: TCCA approved Dart Aerospace Ltd. Master Document List MDL-D350-822 Revision H, dated July 21, 2015, or later TCCA approved revision.

Basis of Certification for affected areas: AWM 527 at Change 527-3 plus technical standards contained in 14 CFR Part 27 up to amendment 27-32.

— End —

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.



Greg Oucharek
For Minister of Transport

Work Order ID 162541

Monday, June 05, 2017 9:30:29 AM

162541

Page 1

Item ID: D350-822-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 6/1/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/5/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: 21 Date: **JUN 07 2017** Tooling: 220 Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-822	17-7-11								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.04							
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D350-822-013 CHG001									
110	missing	0.00							
110									
Packaging		0.04							
Packaging	706A33-201-001								
	X2								
120		0.00							
120									
QC		0.06							
Quality Control									

JUL 06 2017

JUN 28 2017

JUL 06 2017



Department of Transport

Supplemental Type Certificate

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

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Issue No.: 2

Approval Date: June 12, 2014

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Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

Airbus Helicopters AS 350 B, AS 350 B1, AS 350 B2,
AS 350 B3, AS 350 BA, EC 130 B4, EC 130 T2.

Canadian Type Certificate or Equivalent:

H-83

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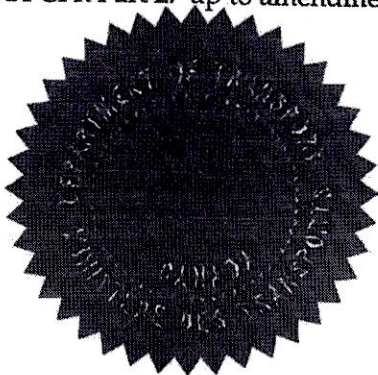
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Basis of Certification for affected areas: AWM 527 at Change 527-3 plus technical standards contained in 14 CFR Part 27 up to amendment 27-32.

— End —

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.



Greg Oucharek
For Minister of Transport

5.0 PARTS LIST

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	X	D350-822-013	PA100 PUREAIR PROVISIONS
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1**		QB21304	PUREAIR PANEL ASSY
1**		QB21310	TRANSITION DUCT ASSY
1**		QB21308	FOD SCREEN ASSY
15**		LN29985-A05	ANCHOR NUT
56**		LN9038-05018	BOLT
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1*	1*	D4931-1	ENGINE FITTING
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1*	1*	D4931-5	ENGINE FITTING
6	6	D4935-1	MOUNTING BRACKET
1	1	D4943-1	FLEX HOSE
1	1	D4961-041	TUBE ASSEMBLY
1	1	D4961-043	TUBE ASSEMBLY
2	2	D5079-1	PLACARD
1	1	D5090-041	DUCT ASSEMBLY
2	2	D5105-1	HANDLE
1	1	D5110-1	SWIVEL NUT FITTING
2	2	D5179-1	DOUBLER
2	2	D5179-3	DOUBLER
2	2	D5194-1	DOUBLER
3	3	D5208-041	BLANKING PLATE ASSY
2	2	23350CA050	LOCKING TAB
1*	1*	9752100180	GASKET
1*	1*	9945000120	GASKET
1*	1*	706A33-201-001	GASKET
2	2	22208CM050016E	SCREW
2	2	AS1034J1212	ELBOW (OR AN821-12K OR AN821-12S OR AN821-12J)
1	1	AN929-12J	CAP
66	66	BS4320-A5	WASHER (OR NAS1149D0332J)
36	36	LN9038-05012	BOLT
1	1	LN9038-05040	BOLT
30	30	LN9348-05	NUT
18	18	MS20470AD3-4	RIVET
1	1	MS21919WCH12	CLAMP (OR MS21919WHG12)
1	1	MS9592-138	BRACKET
1	1	NAS43DD3-64	SPACER

* USE APPROPRIATE FITTING/GASKET BASED ON ENGINE INSTALLATION

** PART OF QB05008 ABOVE

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Revision: G
Date: 17.06